

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025658**Date Inspected:** 16-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No			
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No	N/A
				<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG				

**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. This QA Inspector observed the following:

Caltrans and ABF have agreed to conduct visual and magnetic particle inspections (MT) of segment 13West welds as part of a special inspection program, reference NWIT number 9751. This QA Inspector observed ABF Inspectors had completed and accepted MT inspections of welds: SEG3013W-002, 003, 004, 005, 006, 044, 045, 050, 051, 094, 095, 112, 113, 150, 152, 153, 156, 157, OBW13AA-001, 002, 003, 004; LD3050-001-013, 014, 019 and 020. This QA Inspector performed random visual and magnetic particle inspection of welds: SEG3013W-003, 007, 045, 051, 095, 113, 150, 151, 152, 153, 156; OBW13AA-001, 002, 003, 004 and these welds appear to comply with AWS D1.5 MT and visual requirements. For additional information on these inspections see this QA Inspector's TL6028 Magnetic Particle Test Report.

This QA Inspector observed ZPMC appears to have hand cut FL3 stiffener pass through slots in segment 13West FL3 plates as shown on drawing SEG3013W and SEG3013V. Below is a copy of the incident report describing this nonconformance:

Description of Incident: During Quality Assurance (QA) random in process observations of Segment 13W, this QA Inspector discovered the following issues:

- Cut edges that do not meet the requirements of the contract documents.
- Stiffener pass-through slots that do not meet the dimensional specifications of the approved shop drawings.

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-All of the flame cut areas are “as cut” and have not been ground smooth.

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## WELDING INSPECTION REPORT

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This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 150-0042-2372 , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Dawson,Paul	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley,Ken	QA Reviewer

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